

Date: Tuesday, 08/04/2008 4:54:55 PM
 User: Julie Lecocq

Process Sheet

| | |
|---|---|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : 350 SKIDTUBE EXTRUSION (BENT) |
| Job Number : 38463 | |
| Estimate Number : 10997 | |
| P.O. Number : | Part Number : D26003BENT |
| This Issue : 08/04/2008 S.O. No. : | Drawing Number : D2600 D1/D2750 E |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : 11 Type : MACHINED PARTS | Drawing Revision : D1/E |
| Previous Run : 37858 | Material : |
| Written By : | Due Date : 30/04/2008 Qty: 30 / 12 Um: Each |
| Checked & Approved By : JD 08.4.09 | |
| Comment : Est. B02.11.28 Reformat KJ | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|-----------|------------------------|
| 1.0 | D26003120 | Extrusion Round 3" 350 |
|-----|-----------|------------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Extrusion Bent

Pick:

| | | | |
|-----|-------------|-------------|--------|
| Qty | Part Number | Description | Batch |
| 1 | D2600-3 | Extrusion | B30682 |

PL 8-4-17 (31)

| | | |
|-----|---------|-----------------------------|
| 2.0 | BENDING | BENDING MACHINE - SKIDTUBES |
|-----|---------|-----------------------------|



(Pb)

Comment: BENDING MACHINE

Deburr one end of extrusion

Drill #30 pilot holes using DT8689

Open holes to 5/16" and deburr

Bend using CNC bending machine as per program 2750.C and Folio FT003.

Use 5/16 locator pin on buggy "A".

Check fit to Jig DT8150

PL 8-4-18 (30)

| | | |
|-----|-----|------------------------------|
| 3.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|

**Comment:** INSPECT WORK TO CURRENT STEP

Inspect work to Step 6 Ensure fit to Jig DT8150

Log 8-4-18 (30)

| | | |
|-----|-------------|-----------------------|
| 4.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|

**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: LG (Skid tubes)

PL 8-4-18

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D2600-3-BENT PAR #: N/A Fault Category: Prod / Skid / He NCR: Yes No DQA: D Date: 08/04/23
QA: N/C Closed: D Date: 08/04/23

| NCR: <u>38463</u> | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|-------------------|------|---|-----------------------------|---|----------------------------|-----------------------------|-----------------------|-----------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 08/04/18 | 20 | 1. tube was over bent on the Bender. tube was under bent at first and Bender operator tried to Rebend. First tube. Over Bent b 1.5' | <u>Dosher</u> | Scrap and Destroy and replace Qty <u>(X1)</u> B# <u>30682</u> | <u>DZ</u> <u>8-9-18</u> | <u>D</u> <u>08/04/18</u> | <u>Dosher</u> | <u>G</u> <u>08/04/18</u> |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE EXTRUSION (BENT)

Job Number: 38463

Part Number: D26003BENT

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/21

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



UMF 08-04-21

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
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| CHECKED <i>KE</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2600 | REV. 0 SHEET 1 OF 5 |
| DATE 98.08.20 | | TITLE EXTRUSION | SCALE 1:1 |
| A | 97.01.21 | NEW ISSUE | |
| B | 97.09.09 | CHANGE MATERIAL SPEC. | |
| C | 98.04.16 | ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO. | |
| D | 98.08.20 | INCREASE MIN. UTS TO 40 KSI | |
| DI | 01.04.17 | ADD PART NUMBERS & DIE NUMBERS <i>4-CP</i> | |

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98.08.25 DS

GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED
TO ASTM STANDARD B221 BY AN APPROVED TESTING
FACILITY TO ENSURE THAT THE BATCH MEETS THE
ABOVE MINIMUM MECHANICAL PROPERTIES.

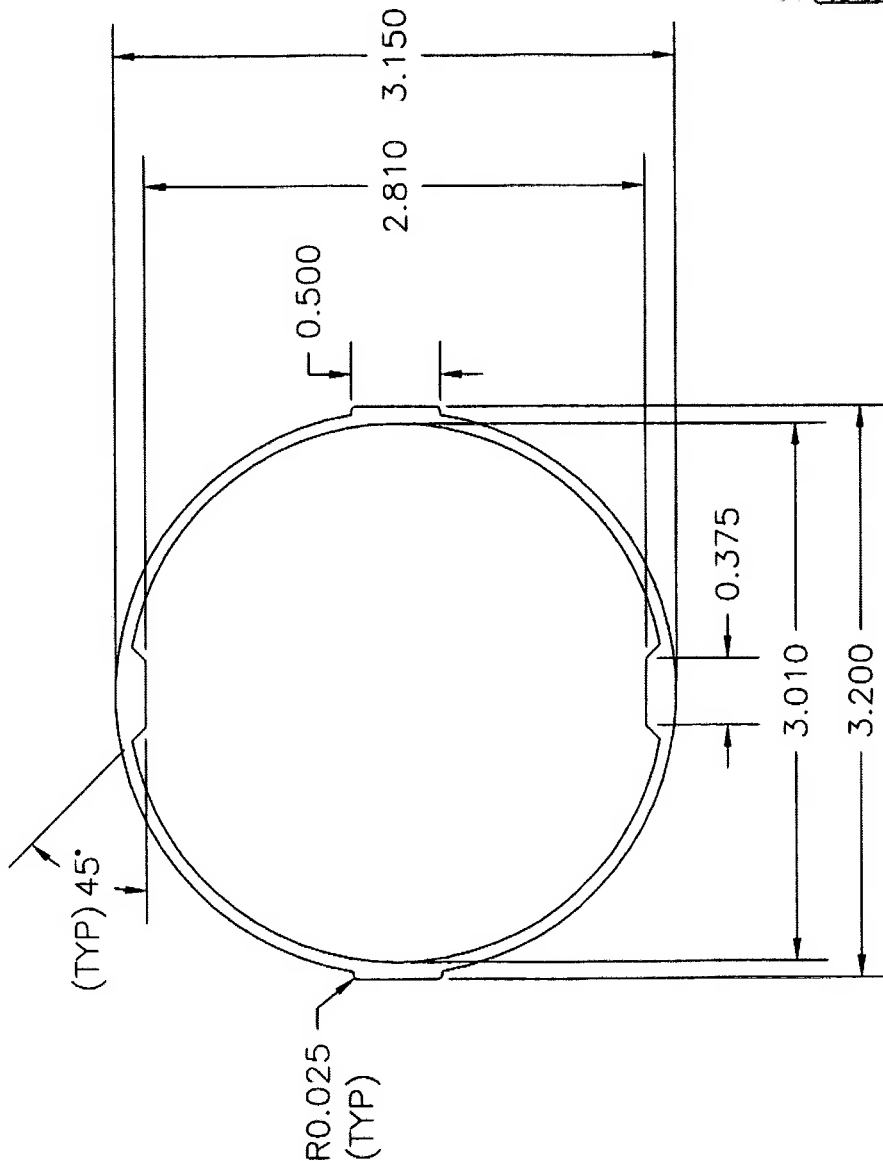
2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5. ALL DIMENSIONS ARE IN INCHES.

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| DATE 98.08.20 | | TITLE EXTRUSION | SCALE 1:1 |

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98.8.25 DS



D2600-1

MANUFACTURED WITH CARADON INDALOX DIE # MH-18870
OR BON L DIE # 89712-1 (PREFERRED CHOICE)

PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 IS 160" LONG)

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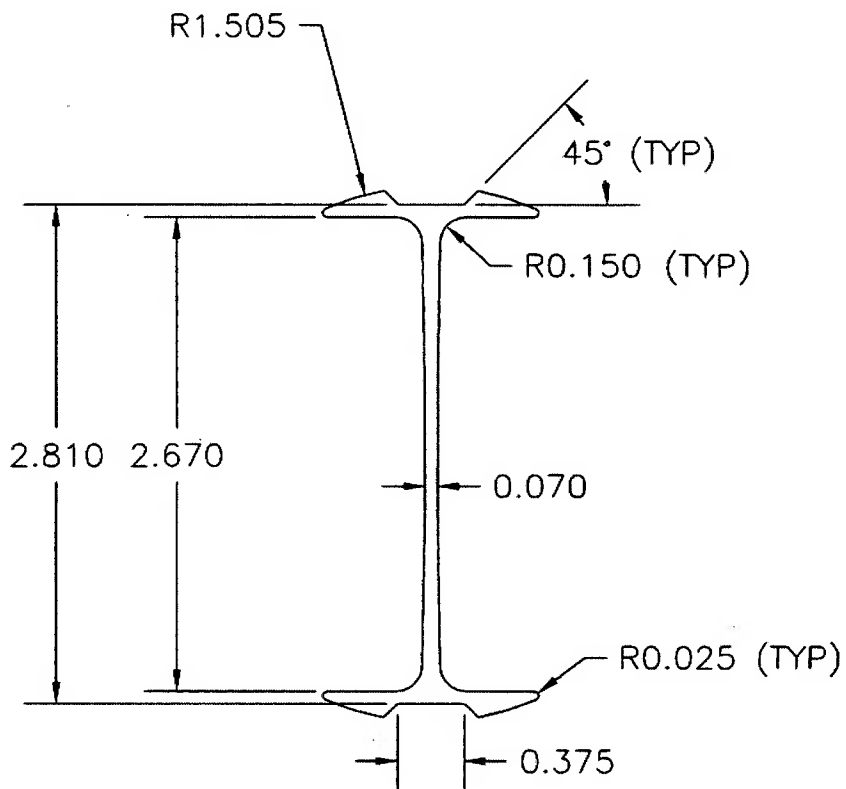


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| DATE | | TITLE | SHEET 4 OF 5 |
| 98.08.20 | | EXTRUSION | SCALE |
| | | | 1:1 |

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98.8.25. BS



D2600-5

MANUFACTURED WITH CARADON INDALEX DIE # MS-18871
PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-5-108 IS 108" LONG)



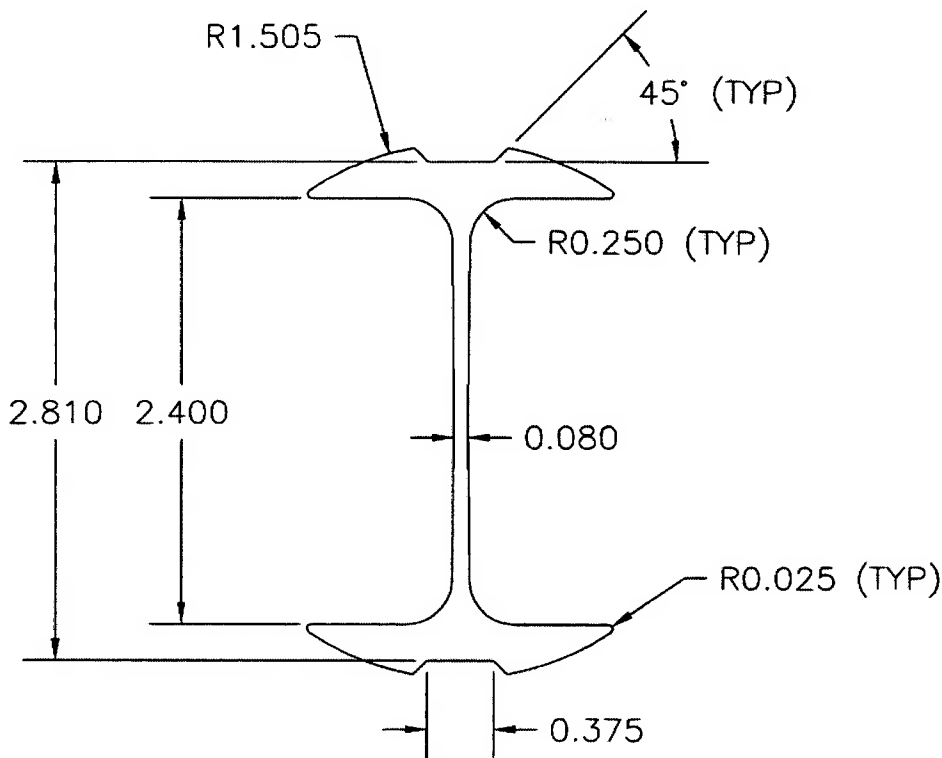
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| DATE | | D2600 | SHEET 5 OF 5 |
| 98.08.20 | | TITLE | SCALE |
| | | EXTRUSION | 1:1 |

RELEASED
98.8.25 DS



D2600-7

MANUFACTURED WITH CARADON INDALEX DIE # MS-18872
PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-7-125 IS 125" LONG)



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| DATE 07.05.17 | | TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS | |
| REV | DATE | DESCRIPTION | |
| A | 98.04.16 | NEW ISSUE | |
| B | 98.09.01 | CHANGE MS24694-S293 TO AN8-16A | |
| C | 98.11.18 | ADD D2750-3 / D2750-4; INCORPORATE D2738 AND D2740 | |
| D | 06.01.05 | ADD HOLES AND SPACERS FOR APICAL FLOATS INCORPORATE DEO 9133 / 9157 | |
| E | 07.05.17 | CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY(38) NAS1515H3L; REMOVE QTY(10) NAS1515H8L; REMOVE D2741, QTY(2) AN960C816; REMOVE QTY(2) MS21083C8 | |

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| Qty -041 | Qty -042 | Qty -043 | Qty -044 | Part Number | Description |
|-------------|-------------|-------------|-------------|---------------|--|
| X | | | | D2750-041 | SKIDTUBE ASSEMBLY, LH |
| | X | | | D2750-042 | SKIDTUBE ASSEMBLY, RH |
| | | X | | D2750-043 | SKIDTUBE ASSEMBLY, LH |
| | | | X | D2750-044 | SKIDTUBE ASSEMBLY, RH |
| 1 | 1 | 1 | 1 | D2739 | WEB |
| 8 | 8 | 8 | 8 | D2743 | SPACER |
| 1 | 1 | 1 | 1 | D2744 | CAP |
| 8 | 8 | 8 | 8 | D2745 | BUSHING |
| 1 | | | | D2750-1 | SKIDTUBE WELDMENT, LH |
| | 1 | | | D2750-2 | SKIDTUBE WELDMENT, RH |
| | | 1 | | D2750-3 | SKIDTUBE WELDMENT, LH |
| | | | 1 | D2750-4 | SKIDTUBE WELDMENT, RH |
| 1 | | 1 | | D3488-041 | BLADE FITTING, LH |
| | 1 | | 1 | D3488-042 | BLADE FITTING, RH |
| 4 | 4 | 4 | 4 | D3490-1 | SPACER |
| 4 | 4 | | | D3490-3 | SPACER |
| | | 4 | 4 | D3490-5 | SPACER |
| 8 | 8 | 8 | 8 | D3492-041 | PLUG ASSEMBLY |
| 8 | 8 | | | D3492-043 | PLUG ASSEMBLY |
| | | 8 | 8 | D3492-045 | PLUG ASSEMBLY |
| 1 | 1 | 1 | 1 | D3535-13 | WEARSHOE |
| 1 | 1 | 1 | 1 | D3535-25 | WEARSHOE |
| 1 | 1 | 1 | 1 | D3535-35 | WEARSHOE |
| 1 | 1 | 1 | 1 | D3536-13 | GASKET |
| 1 | 1 | 1 | 1 | D3536-25 | GASKET |
| 1 | 1 | 1 | 1 | D3536-35 | GASKET |
| 5 | 5 | 5 | 5 | D3537-1 | WEARPAD |
| 8 | 8 | 8 | 8 | D3631-1 | WASHER |
| 42 | 42 | 42 | 42 | ALS4-1032-225 | INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225) |
| 38 | 38 | 38 | 38 | AN3C5A | BOLT |
| 4 | 4 | 4 | 4 | AN3C6A | BOLT |
| 4 | 4 | 4 | 4 | AN3C7A | BOLT |
| 4 | 4 | 4 | 4 | AN6C44A | BOLT |
| 1 | 1 | 1 | 1 | AN8C35A | BOLT |
| 46 | 46 | 46 | 46 | AN960C10L | WASHER |
| 2 | 2 | 2 | 2 | AN960C816L | WASHER |
| 4 | 4 | 4 | 4 | MS21043-6 | NUT |
| 1 | 1 | 1 | 1 | MS21083C8 | NUT |
| 4 | 4 | 4 | 4 | NAS1515H3L | WASHER |
| 2 | 2 | 2 | 2 | NAS1515H8L | WASHER |

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| DATE 07.05.17 | | TITLE 350 SKIDTUBE ASSEMBLY | SCALE NTS |

GENERAL NOTES:

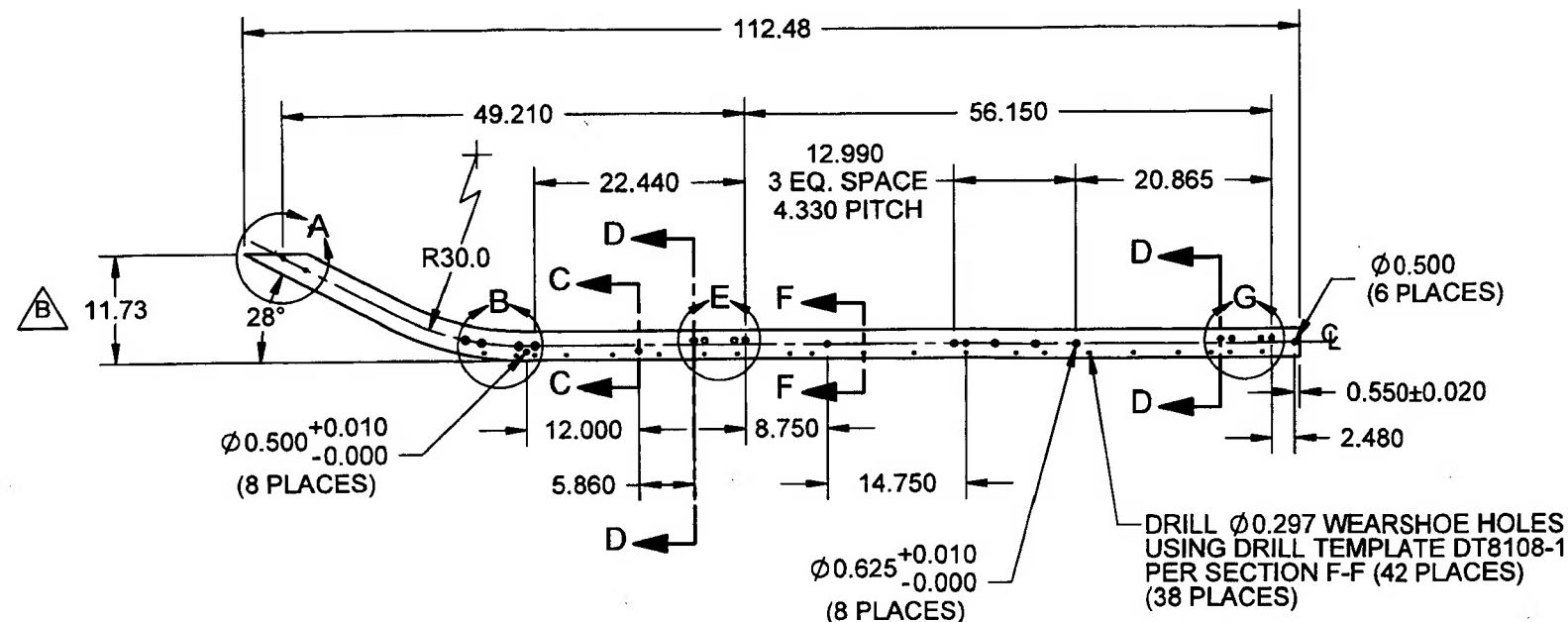
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1. ALL DIMENSIONS ARE IN INCHES.
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.15 ± 0.030 IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS C-C, D-D AND F-F.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4 AND 5. DRILL 'F' SIZE HOLES ($\emptyset 0.297$) FOR WEARSHOE INSERTS.
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3C5A/AN3C7A WEARSHOE BOLTS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS POWDER COATING WITH MEK DEGREASER.

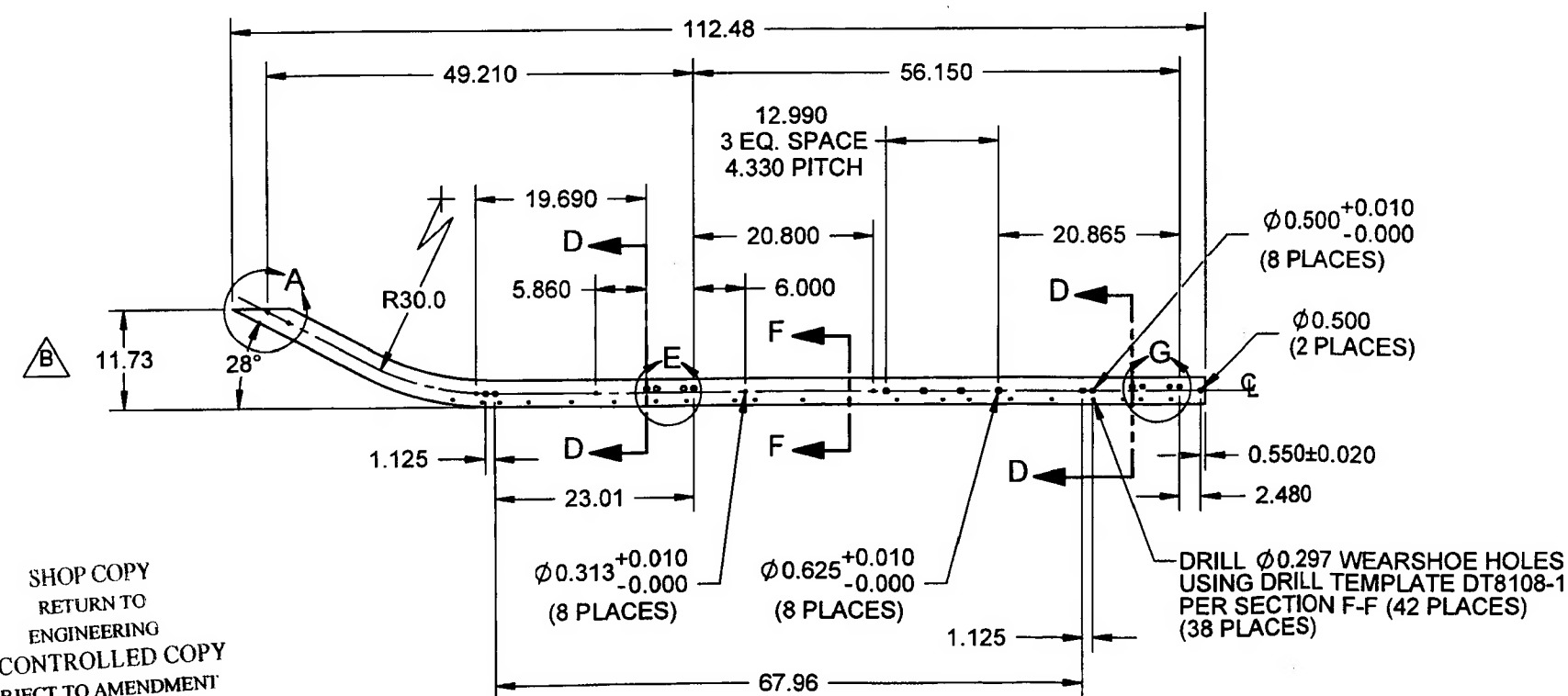
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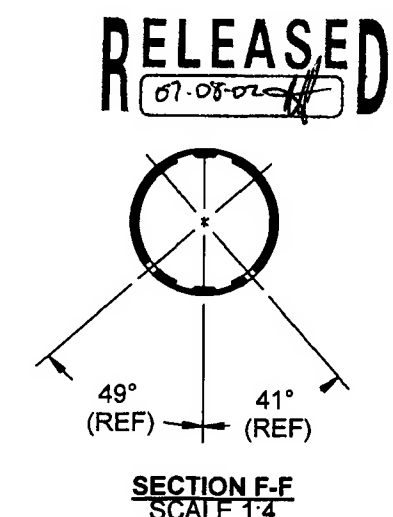
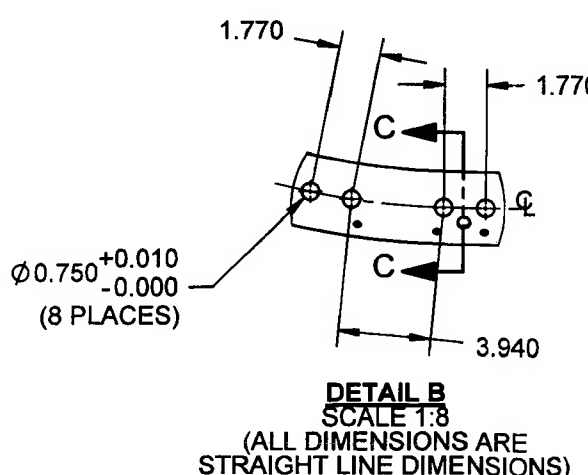
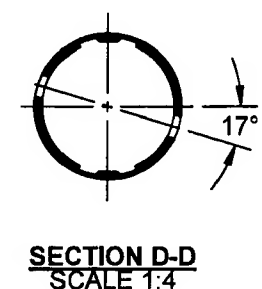
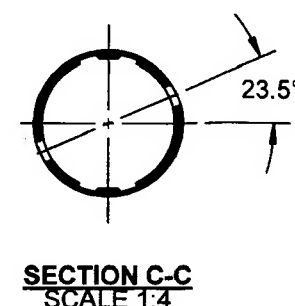
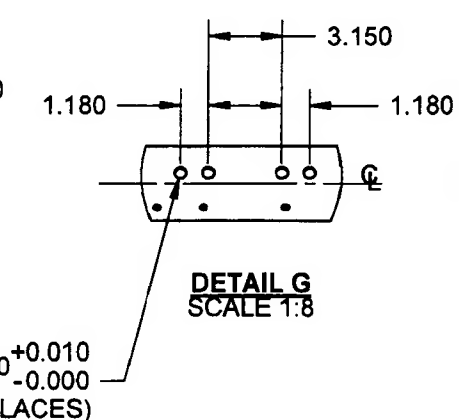
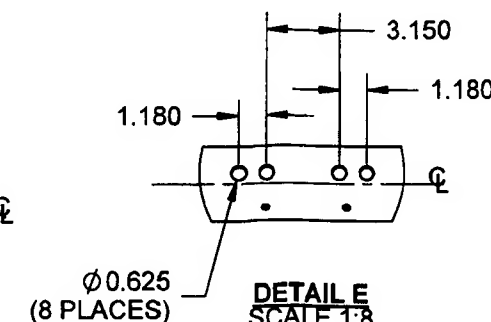
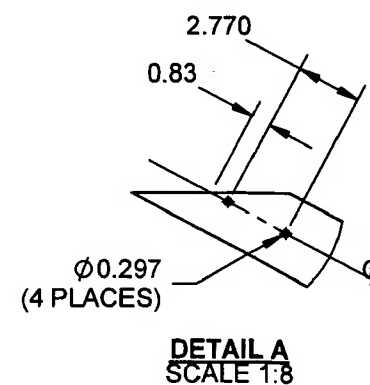
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D2750-1 LH SKIDTUBE (SHOWN)
D2750-2 RH SKIDTUBE (OPPOSITE)



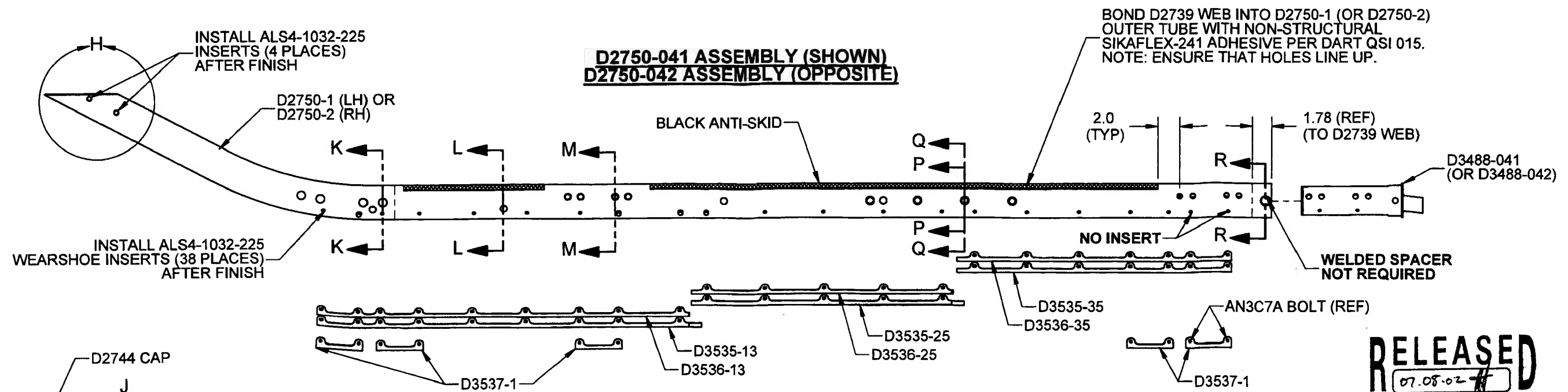
D2750-3 LH SKIDTUBE (SHOWN)
D2750-4 RH SKIDTUBE (OPPOSITE)



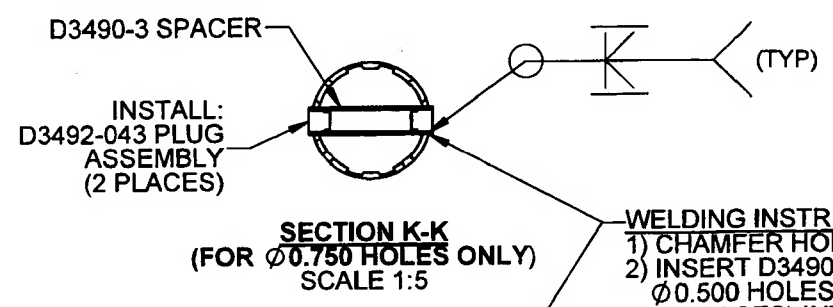
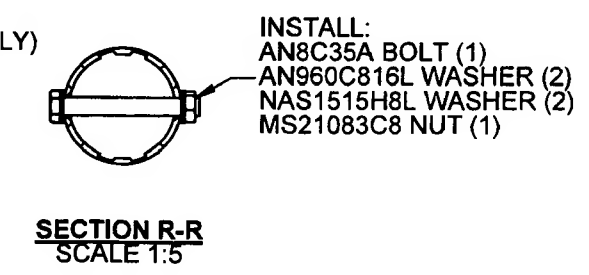
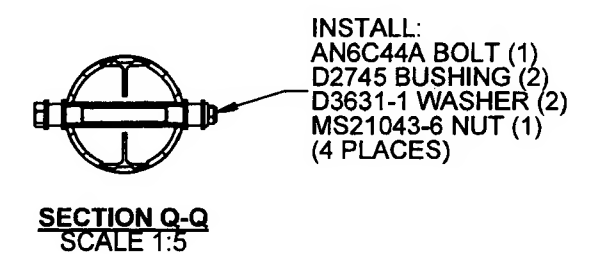
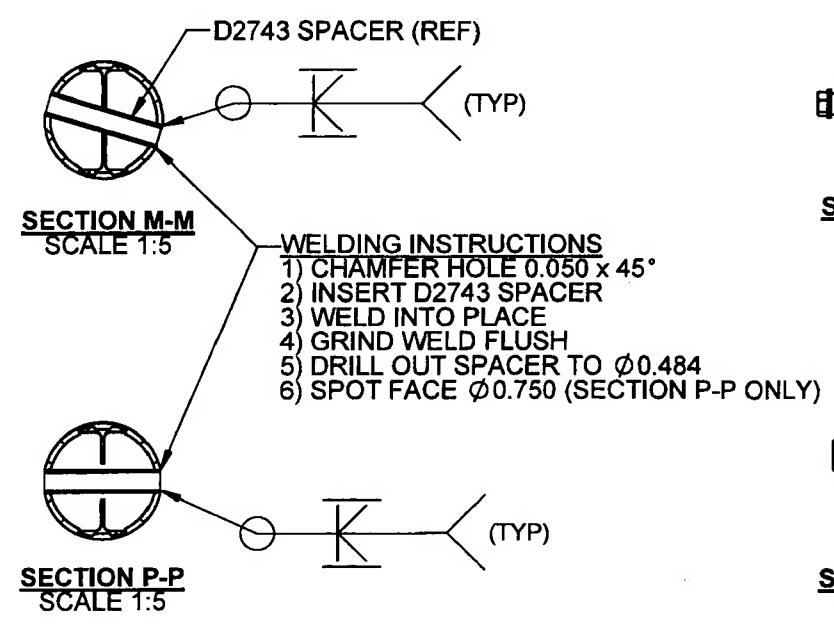
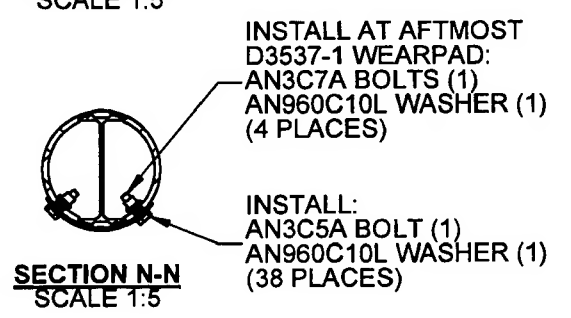
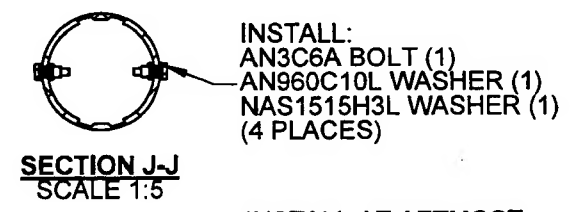
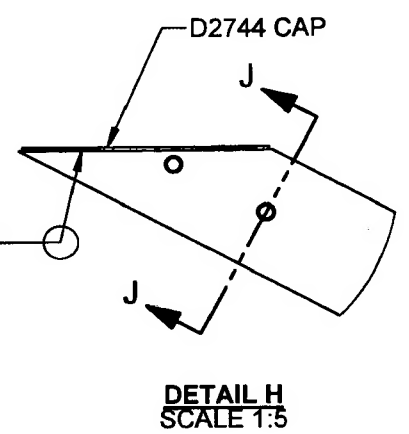
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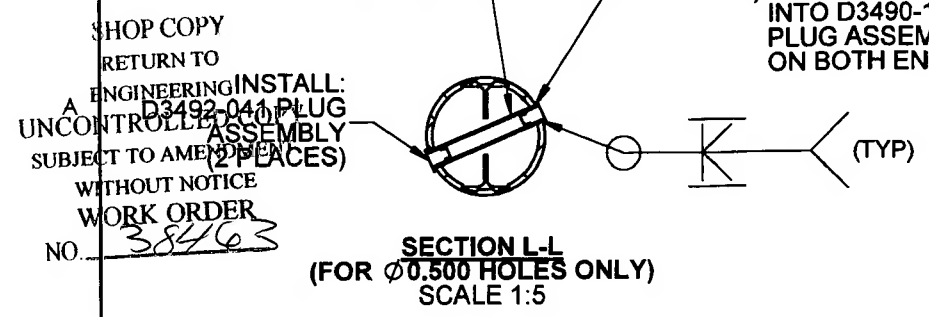
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| DATE 07.05.17 | | TITLE 350 SKIDTUBE ASSEMBLY | SCALE 1:20 |
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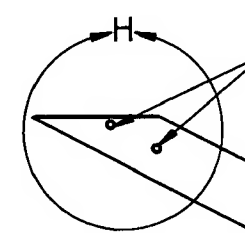
WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 x 45°
2) INSERT D3490-1 SPACER (4 PLACES) INTO Ø0.500 HOLES OR INSERT D3490-3 SPACER (4 PLACES) INTO Ø0.750 HOLES
3) WELD INTO PLACE
4) GRIND WELD FLUSH
5) INSERT D3492-041 PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER OR INSERT D3492-043 PLUG ASSEMBLY (8 PLACES) INTO D3490-3 SPACER ON BOTH ENDS AFTER FINISH



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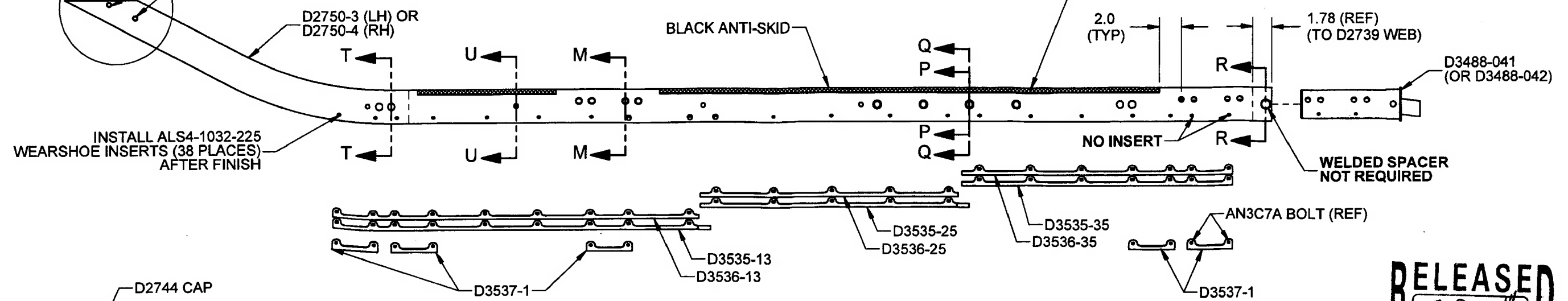
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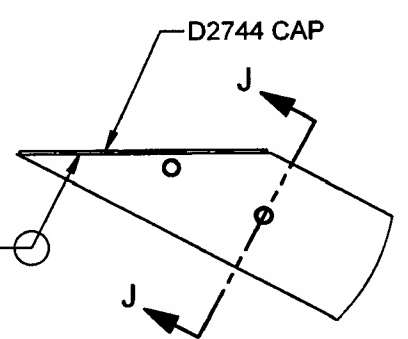
INSTALL ALS4-1032-225
INSERTS (4 PLACES)
AFTER FINISH

**D2750-043 ASSEMBLY (SHOWN)
D2750-044 ASSEMBLY (OPPOSITE)**

BOND D2739 WEB INTO D2750-3 (OR D2750-4)
OUTER TUBE WITH NON-STRUCTURAL
SIKAFLEX-241 ADHESIVE PER DART QSI 015.
NOTE: ENSURE THAT HOLES LINE UP.



RELEASED
07-08-02

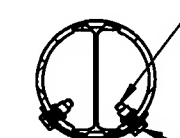


**DETAIL H
SCALE 1:5**



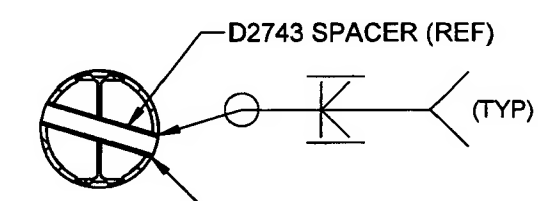
**SECTION J-J
SCALE 1:5**

INSTALL AT AFTMOST
D3537-1 WEARPAD:
AN3C7A BOLTS (1)
AN960C10L WASHER (1)
(4 PLACES)



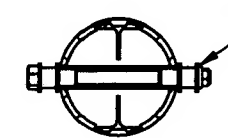
**SECTION N-N
SCALE 1:5**

INSTALL:
AN3C5A BOLT (1)
AN960C10L WASHER (1)
(38 PLACES)



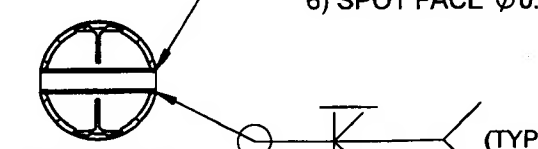
**SECTION M-M
SCALE 1:5**

WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 x 45°
2) INSERT D2743 SPACER
3) WELD INTO PLACE
4) GRIND WELD FLUSH
5) DRILL OUT SPACER TO Ø0.484
6) SPOT FACE Ø0.750 (SECTION P-P ONLY)

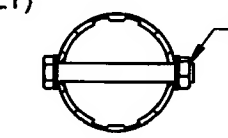


**SECTION Q-Q
SCALE 1:5**

INSTALL:
AN6C44A BOLT (1)
D2745 BUSHING (2)
D3631-1 WASHER (2)
MS21043-6 NUT (1)
(4 PLACES)



**SECTION P-P
SCALE 1:5**



**SECTION R-R
SCALE 1:5**

INSTALL:
AN8C35A BOLT (1)
AN960C816L WASHER (2)
NAS1515H8L WASHER (2)
MS21083C8 NUT (1)

**SECTION T-T
(FOR Ø0.500 HOLES ONLY)
SCALE 1:5**

**SECTION U-U
(FOR Ø0.313 HOLES ONLY)
SCALE 1:5**

WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 x 45°
2) INSERT D3490-5 SPACER (4 PLACES) INTO
Ø0.313 HOLES OR INSERT D3490-1 SPACER
(4 PLACES) INTO Ø0.500 HOLES
3) WELD INTO PLACE
4) GRIND WELD FLUSH
5) INSERT D3492-045 PLUG ASSEMBLY (8 PLACES)
INTO D3490-5 SPACER OR INSERT D3492-043
PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER
ON BOTH ENDS AFTER FINISH

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|--|--------------------------------|--|------------------------|
| DESIGN PH | DRAWN BY CB | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED PH | APPROVED [Signature] | DRAWING NO. D2750 | REV. E SHEET 5 OF 5 |
| DATE 07.05.17 | TITLE 350 SKIDTUBE ASSEMBLY | SCALE 1:10 | |
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